

Date: Thursday, 17/04/2008 7:42:44 AM  
 User: Linda Lacelle

## Process Sheet

*spirit who  
as 08/05/13*

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: HI-STEP LEG ASSEMBLY	
Job Number	: 38650 <i>✓</i>				Part Number	: D3065041	
Estimate Number	: 10385				Drawing Number	: D3065 REV B	
P.O. Number	:				Project Number	: N/A	
This Issue	: 17/04/2008	S.O. No.	:		Drawing Revision	: B	
Prsh Rev.	:	NC			Material	:	
First Issue	: 17/04/2008	Type	:	SMALL /MED FAB	Due Date	: 06/05/2008	Qty: <i>50</i> Um: Each
Previous Run	:	35626					
Written By	:	<i>U</i>					
Checked & Approved By	:						
Comment	:	Est Rev: C	02.11.01	Incorporated D3066-1 IPP KJ/RF			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	38650A	STEP SPACER	
		<i>Comment: Sub-Component STEP SPACER D3065-1 B 38650A</i>	<i>E Pos/06/20</i>
2.0	38650B	STEP SPACER	
		<i>Comment: Sub-Component STEP SPACER D3065-3 B 38650B</i>	<i>E Pos/06/20</i>
3.0	38650C	STEP LEG	
		<i>Comment: Sub-Component STEP LEG D3065-5 B 38650C</i>	<i>E Pos/06/20</i>
4.0	38650D	STEP SPACER	
		<i>Comment: Sub-Component STEP SPACER D3065-7 B 38650D B37771</i>	<i>E Pos/06/20</i>
5.0	MS20470AD44	Rivet, Universal Head	
		<i>Comment: Qty.: 30.0000 Each(s)/Unit Total : 3000.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description Batch</i>	<i>E Pos/06/20</i>
	30 MS20470AD4-4	Rivet	<i>M107823</i>

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User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 38650

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

*28/06/08 (50)*

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*28/06/08 (50) counter*

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W4 11.18.19*

*14 08.06.25 50*

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*14 08/06/08 (50)*

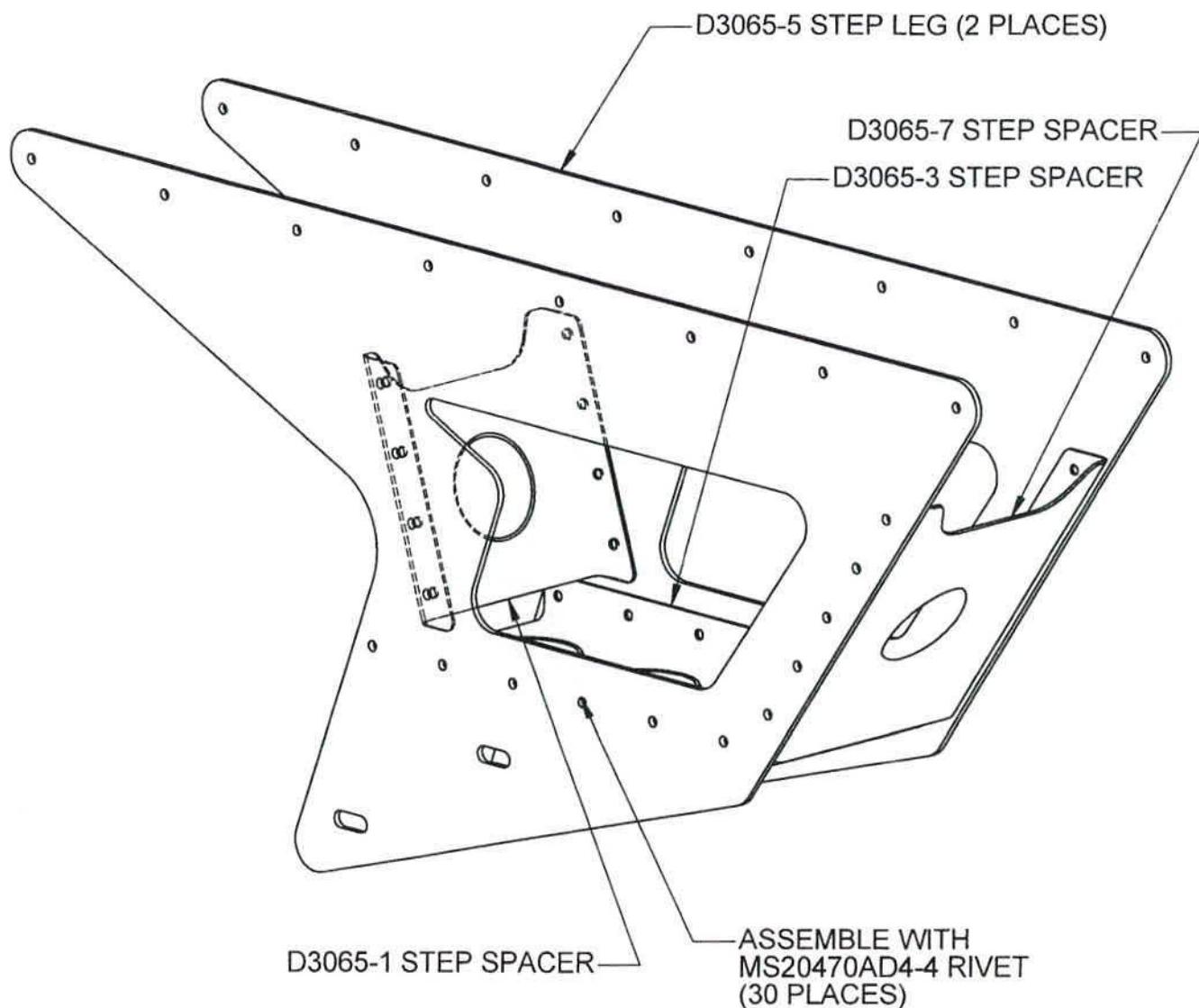
Job Completion



*MF 08-06-26*

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D3065	REV. B	SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2	
A	02.09.11	NEW ISSUE		
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5		

**RELEASED**06.06.20 *TH***D3065-041 STEP LEG ASSEMBLY**

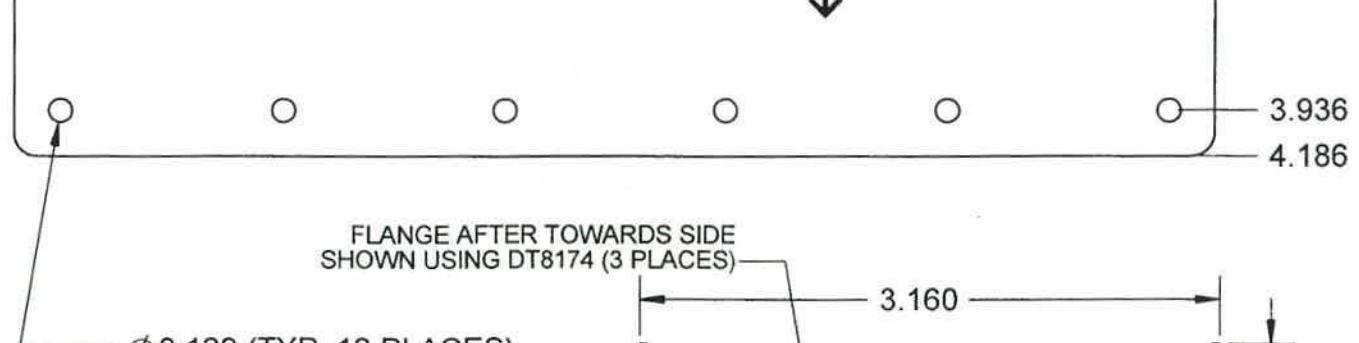
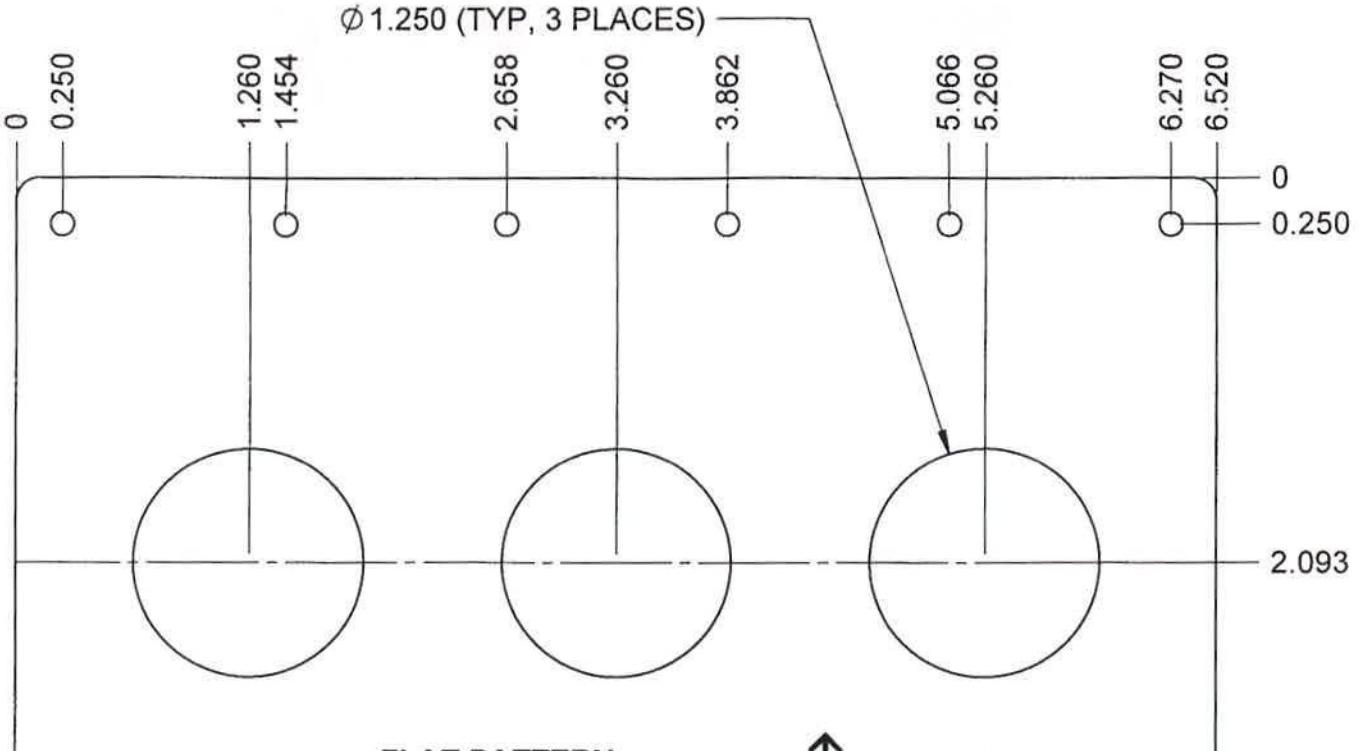
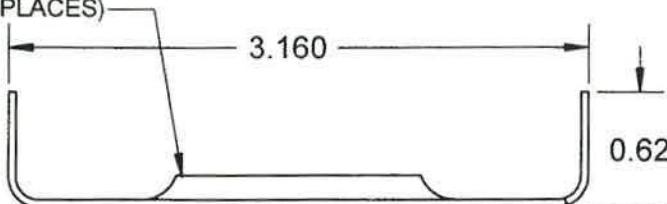
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*(208/04/17)  
W10: 38650*

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>M</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES) $\phi 0.129$  (TYP, 12 PLACES)**RELEASED***06.06.20 - M***D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

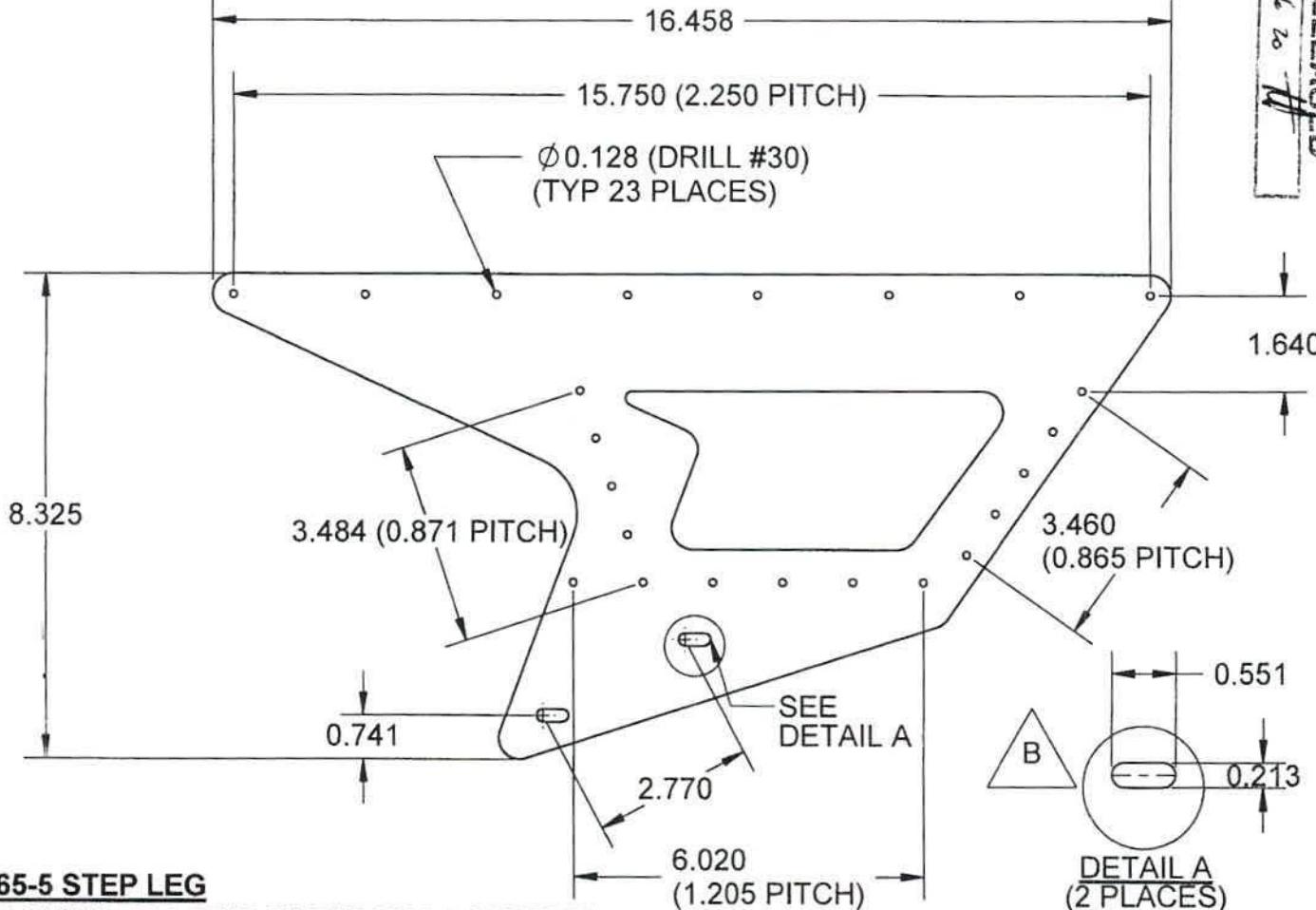
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*C208/04/17  
W10:38650*

**DART**

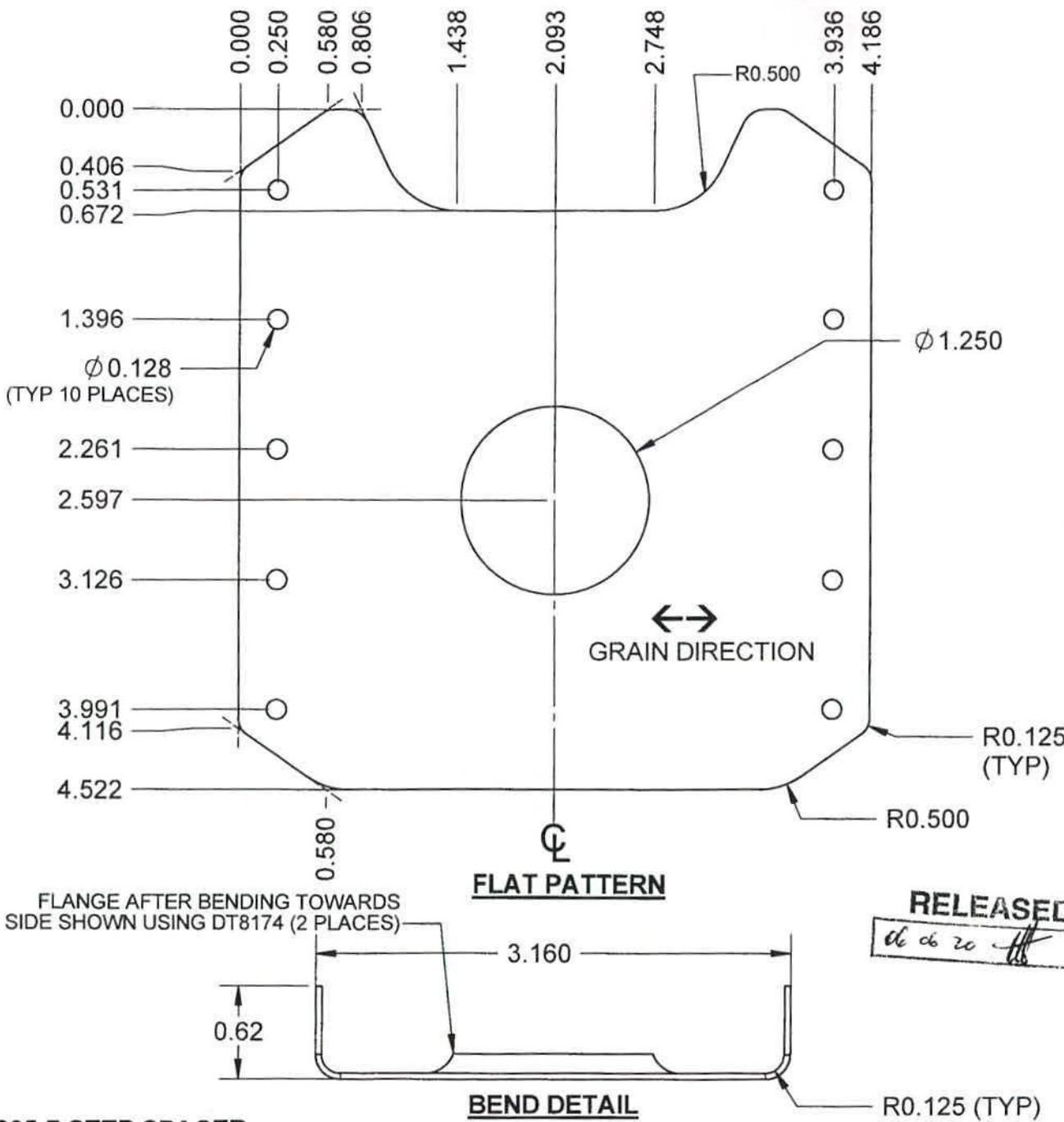
DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. <b>D3065</b>
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 4 OF 5 SCALE 1:3

**RELEASED**  
*6.6.20 H***D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065
DATE 06.05.23		REV. B SHEET 5 OF 5 TITLE STEP LEG ASSEMBLY SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

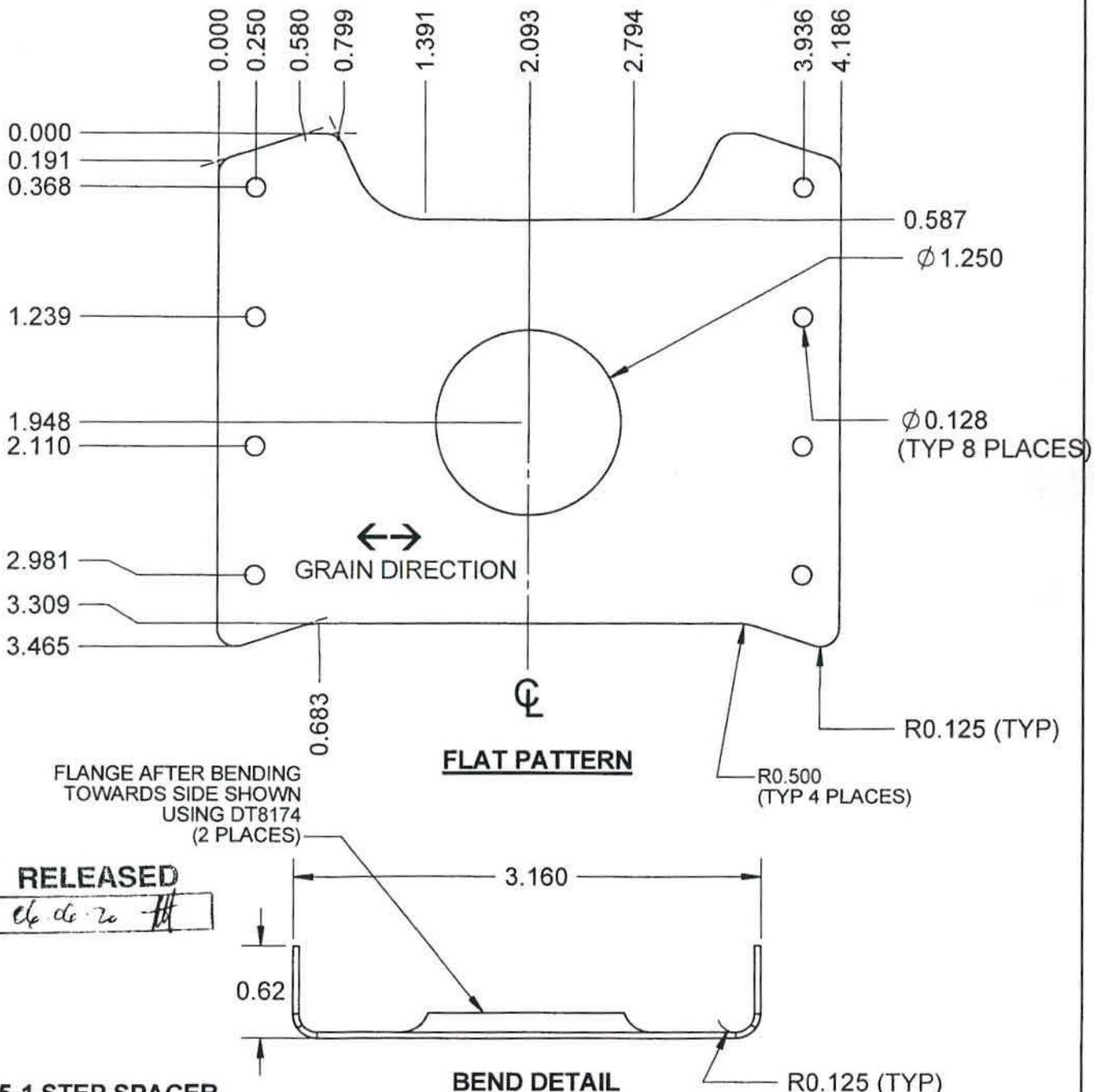
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*C208/04/17  
W10: 38650*

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 2 OF 5 SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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*cL08/04/17  
W10:38650*